

Date: Wednesday, 2/15/2006 3:45:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOCK PLATE
Job Number : 25825A	
Estimate Number : 10332	
P.O. Number : N/A	Part Number : D2534
This Issue : 2/15/2006 S.O. No. : N/A	Drawing Number : D2534 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 24876A	Material : N/A
Written By : <u>SRR (COMMENT BELOW)</u>	Due Date : 2/28/2006 Qty: 40 Um: Each
Checked & Approved By : <u>06-02-16</u>	
Comment : Est Rev:A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Order (2) D2534 per (1) D2530

Issue P/O: 603

Email or ship DXF file to vendor

Laser cut D2534 flat pattern per Dwg D2534

Material release note required

u 060216 40

2.0	D2534F	Lock Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)
 Lock Plate

40

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 206103109 40

4.0	QC6	DIMENSIONAL CHECK
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Comment: Inspect dimensions per template D2534-T1

06-03-04

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD / 06/03/24
 06:03:27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:45:54 PM
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Drawing Name: LOCK PLATE

Job Number: 25825A

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48

Job Completion



14/3/29 (40) 02/03/30
Inspection Level 21
U 06.03.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

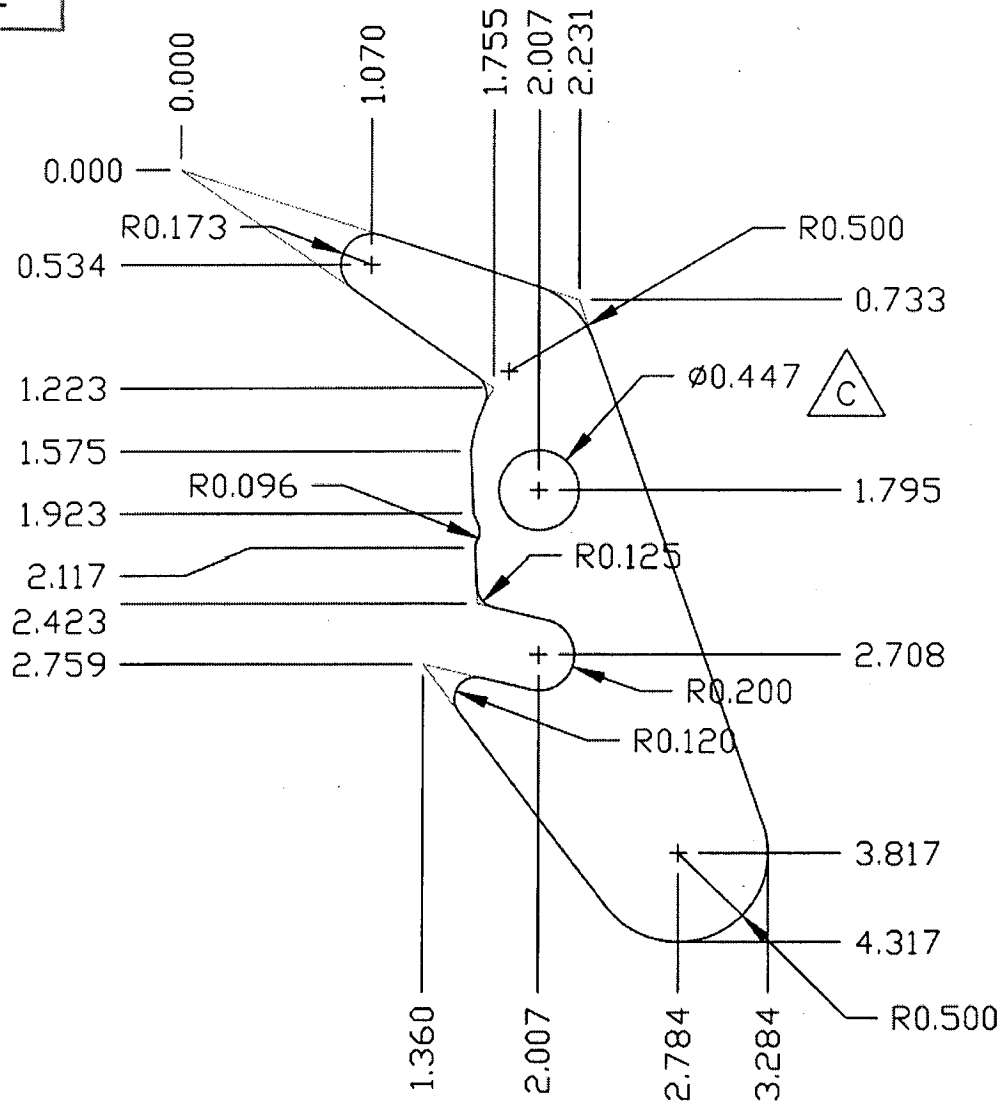
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

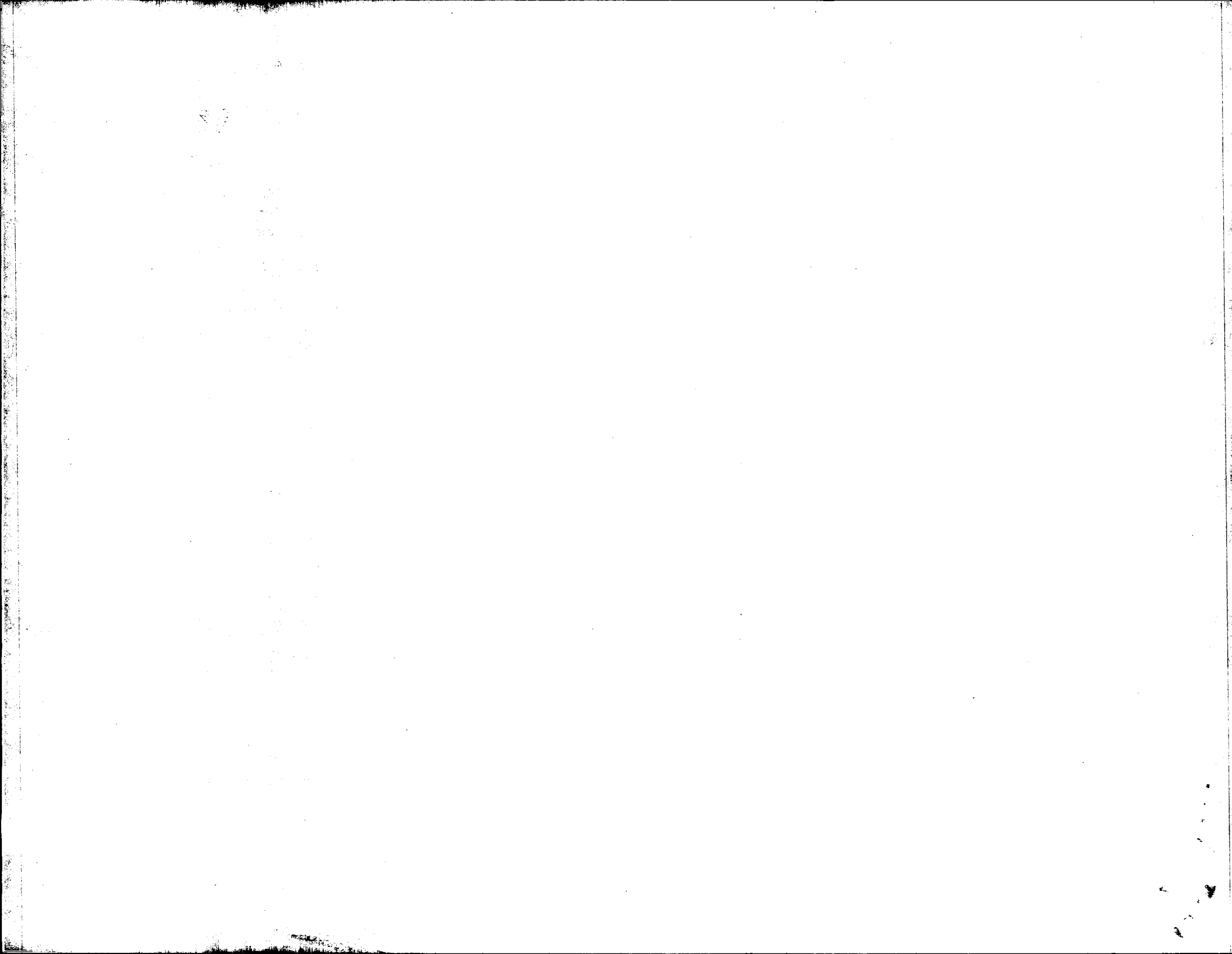
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. D
		D2534	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		LOCK PLATE	1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **25825 A**



P57020PC002

OCT-20-2005 15:05 OLBERT METAL SALES
OLBERT METAL SALES LIMITED
WILKINSON STEEL AND METALS
 STAINLESS COIL COIL 304
 11 GA (11.6) X 48.0000"
 PART NO.

905 795 1320 P.02
 BL VAL-000504-001 200405
 Pg 1/1



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I
 Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No.0035)
 Inspection Certificate EN10204-3.1B

Shanxi Taigang Stainless Steel CO.,LTD Member of Taiyuan Iron and Steel (Group) Co.,LTD				MILL TEST CERTIFICATE							
NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China				MATERIAL AISI304 No.2B Finish							
TEL: (0351)3013328 FAX: (0351)3017816				SPECIFICATION ASTM A240/A480 ASME SA240/SA480							
http://www.tisco.com.cn				L/C NO.							
E-mail: tgbxg@tisco.com.cn				CERTIFICATE NO. 20030636							
				DATE OF ISSUE 11							
CUSTOMER OLBERT				CONTRACT NO. 1149							
Product				Mark of the Manufacturer							
Moulding furnace				Shanxi Taiyuan Stainless Steel Co., Ltd							
Inspector's stamp											
COIL E+VOD											
NO.	Heat No	Coil No.	Quantity	Dimensions			Weight (kg)				
8	QBP1133	5A4-278-4ZB	1	20GA	x 48	x C	8528				
9	Y501898	5A4-419-4ZY	1	14GA	x 48	x C	5396				
10	4501977	5A4-368-1ZB	1	11GA	x 48	x C	5182				
11	4501969	5A4-416-4ZY	1	14GA	x 48	x C	7709				
12	4501968	5A4-415-4ZY	1	14GA	x 48	x C	7495				
13	4501963	5A4-367-1ZB	1	11GA	x 48	x C	8127				
14	4500491	5A5-18-4ZJ	1	20GA	x 48	x C	7868				
Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBP1133	0.049	0.470	1.090	0.023	0.003	18.340	8.050				0.039
Y501898	0.058	0.430	1.000	0.029	0.004	18.420	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.050	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.350	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.000				0.050
Mechanical Properties											
Test No.	Tensile Rm N/mm ²	R _{m0.2} Yield _{0.2%} N/mm ²	R _{m1.0} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness					
						HRB	HV	HRC			
QBP1133-T	670	290		55			175				
Y501898-T	665	289		60		83					
4501977-T	635	279		60		86					
4501969-T	635	298		61		84					
4501968-T	658	294		58		84					
4501963-T	630	283		60		85					
4500491-T	660	329		60			172				
Surface and dimensions controlled: O.K.											
Work Inspection											

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Doc No. 1201 Issued 18 Aug 05 by gavlcm

TOTAL P.02

P.02003